

Work Order ID 124076***124076***

Page 1

Wednesday, September 10, 2014 7:32:53 AM

Item ID: D4672-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Blanking Plate

Start Date: 9/10/14 Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 20.00

20

Customer:

Reference:

Run Start

NR1Approvals: Process Plan: MCSDate: 11-09-10

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4672

A

100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4672

Dwg Rev: AProg Rev: A

2-Deburr as required

(22)

2 / Dec 14 / 09 / 11

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(22)

2 / Dec 14 / 09 / 11

472

Picklist Print

Wednesday, September 10, 2014 7:32:04 AM

Page 1

Work Order ID: 124076

124076

Parent Item: D4672-3

D4672-3

Parent Item Name: Blanking Plate

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 12-07-10 JLM VERIFIED BY:EC
REV:B 12.07.24 AS PER DWG REV.A DD VERF:EC IPP

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S20GA | | Purchased | | No | | 100 | sf | 174.0319 | 0.2 | 5 | | | |

M304S20GA

304/316 .040 Sheet

DL 14/09/11

Location

Loc Qty

Loc Code

MAT020

174.0318948

m126852

0.31

m127454

26.1018948

m128435

94.94

m129128

2.5

m129530

5.2

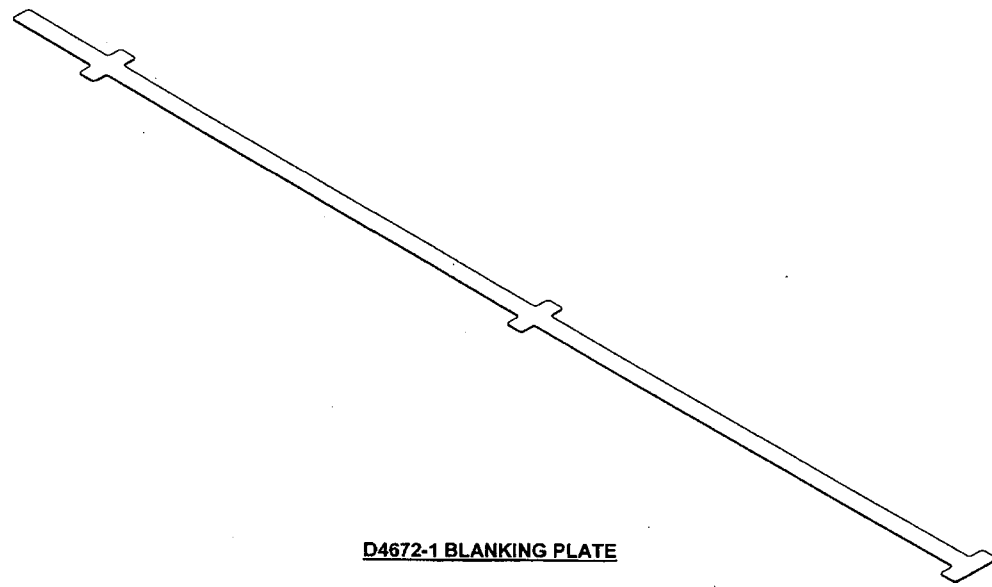
m129845

44.98

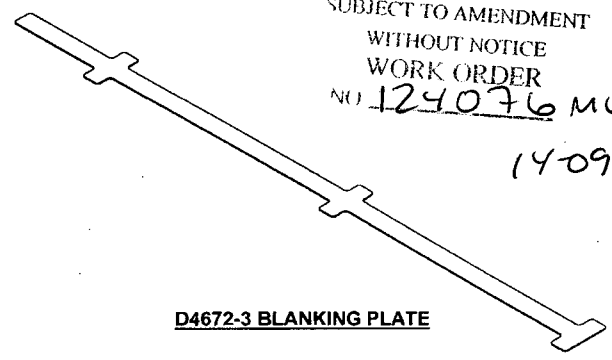
10

8 7 6 5 4 3 2 1

D
C
B
A



D4672-1 BLANKING PLATE



D4672-3 BLANKING PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 124076 MJS
1409-10

RELEASED
2012-07-10
P ELM 12-611

| | | | |
|------------|-------------|----|----------|
| A | NEW ISSUE | MB | 12.06.13 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 12.06.13 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4672**

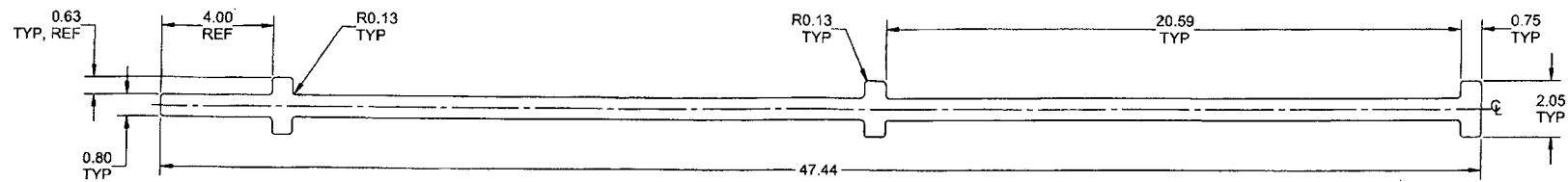
TITLE **BLANKING PLATE**

REV. A
SHEET 1 OF 2
SCALE
NTS

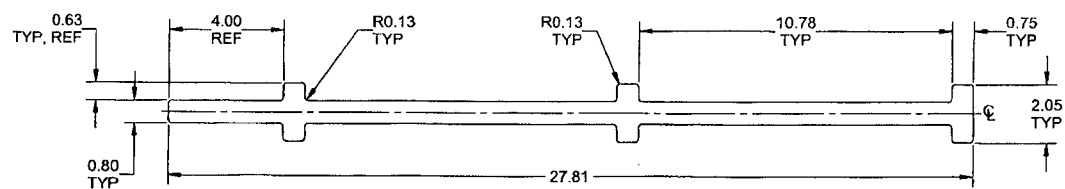
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D4672-1 BLANKING PLATE



D4672-3 BLANKING PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED 2B FINISH PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4672-X" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4672-1 = 0.47 lbs; D4672-3 = 0.29 lbs
- 8) SYMMETRY: ABOUT CENTERLINE OF PART

RELEASED
2012-07-10
9 SEP 12-64

| | | |
|------------|----------|---------------------------------------|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. D4672 REV. A |
| MFG. APPR. | | SHEET 2 OF 2 |
| APPROVED | | TITLE BLANKING PLATE SCALE NTS |
| DE APPR. | | |
| DATE | 12.06.13 | |

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8 7 6 5 4 3 2 1